

Work Order ID 163394

Tuesday, June 27, 2017 11:36:52 AM

163394

Page 2

Item ID: D5122-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Center Support, Upper
 Start Date: 7/6/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/14/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.08				4	0		45 9-89 2017-7-24
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>L653</u> Memo LOCATION: <u>L6054</u>	0.00 0.04				4			DAS 41 9-89 JUL 25 2017
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.40							17/7/25 JF

DAS
21
9-89

JUL 25 2017

Picklist Print

Tuesday, June 27, 2017 11:36:51 AM

Page 1

Work Order ID: 163394

163394

Parent Item: D5122-1

D5122-1

Parent Item Name: Center Support, Upper

Start Date: 7/6/2017

Required Date: 7/14/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV.A NEW ISSUE JFS 14/07/16 VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5122-1TRN		Manufactured	No			100	Each	9.0000	0.5	2	2		DAS
D5122-1TRN									**			12-02-24	39 9-89
Center Support, Upper, Turning Detail													

Location

Loc Qty

Loc Code

MAT060

9

155452

9

2

DART AEROSPACE LTD		Work Order: 163394
Description: Center Support		Part Number: D5122-1
Inspection Dwg: D5122	Rev: A	Page 1 of 1

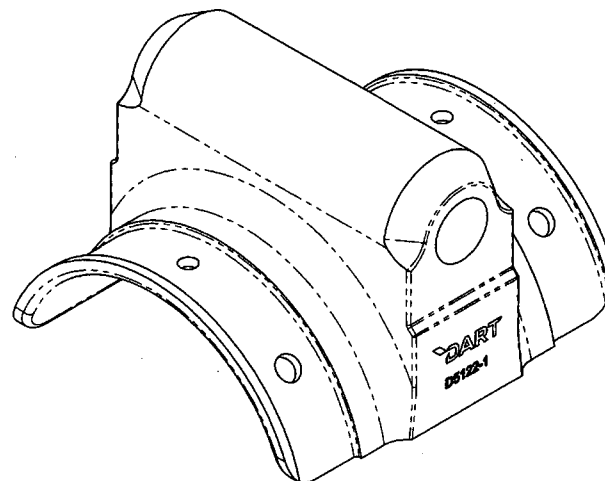
FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	1.182	1.202		1.190	1.190	1.191	1.191	
AB	0.090	0.110		.098	.0985	.099	.099	
AC	0.545	0.565		.550	.553	.552	.552	
AD	3.690	3.700		3.685	3.685	3.684	3.684	
AE	3.550	3.560		3.555	3.555	3.554	3.554	
AF	2.453	2.473		2.462	2.462	2.461	2.462	
AG	1.261	1.281		1.2715	1.2715	1.2755	1.2705	
AH	0.150	0.210		.180	.180	.180	.180	
AI	0.454	0.474		.462	.462	.4605	.462	
AJ	Ø0.260	Ø0.267		.260	.260	.260	.260	
AK	Ø0.188	Ø0.194		.189	.189	.189	.189	
AL	3.067	3.077		3.073	3.073	3.073	3.073	
AM	3.990	4.010		3.997	3.997	3.997	3.997	
AN	1.990	2.010		1.999	1.996	2.001	2.001	
AO	Ø0.625	Ø0.630		.626	.626	.626	.626	
AP								
AQ								
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject				.001	.002	.001	.0005	

DAS

Measured by:	39	Date:	17-07-23
	9-89 DAS		
Audited by:	45	Date:	2017-7-24
	9-89		
Preliminary Approval:		Date:	

Rev	Date	Change	Revised By	Approved
A	15.03.12	New Issue	KJ	



D5122-1 CENTER SUPPORT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *163394* *MCJ*
170703

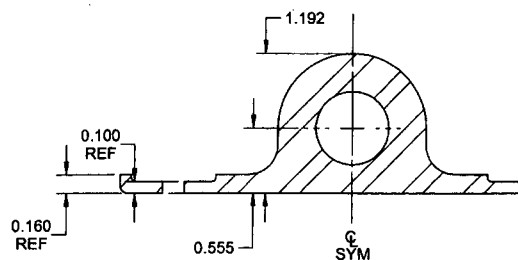
RELEASED
2014-08-25
MP

NOTES:

- 1) MATERIAL: MAKE FROM D5122-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5122-1" IN AREA SHOWN
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 2.13 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5122-1-REVA.SLDPRT"

A		NEW ISSUE		AP	14.06.02	
REV.		DESCRIPTION			BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	AP					
CHECKED	CP	DRAWING NO.	REV. A			
MFG. APPR.	JLM	D5122	SHEET 1 OF 3			
APPROVED	MP	TITLE	SCALE			
DE APPR.	DS	CENTER SUPPORT	NTS			
DATE		14.06.02				
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APPROVED



SECTION A-A

HOLES PERPENDICULAR
WITHIN 0.005 OVER
ENTIRE LENGTH

R0.063
AROUND INSIDE EDGE

0.464 REF

OPTIONAL $\phi 0.261$ REF
TOOLING HOLE,
LOCATED AT 45° TO VERTICAL
4 PL

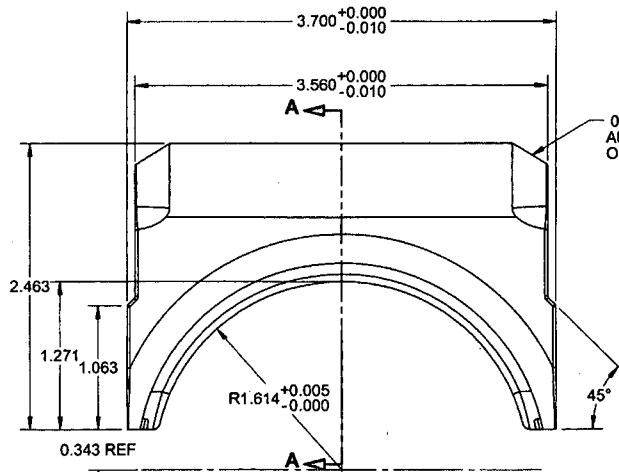
OPTIONAL $\phi 0.189$ REF
TOOLING HOLE,
2 PL

HOLES PERPENDICULAR
WITHIN 0.005 OVER
ENTIRE LENGTH

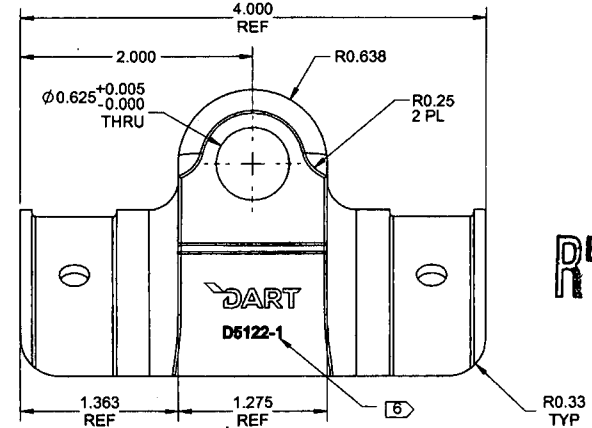
3.072 REF

4.000
REF

0.18 X 58° CMF
ALONG TOP EDGE
OF R0.638 (REF) EDGE



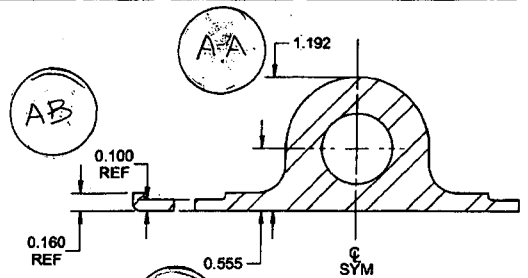
D5122-1 CENTER SUPPORT



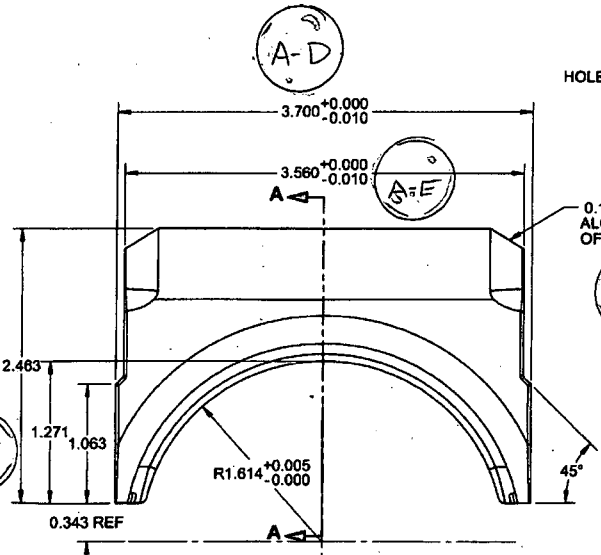
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2014-08-25

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DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5122	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	CENTER SUPPORT	NTS
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SECTION A-A



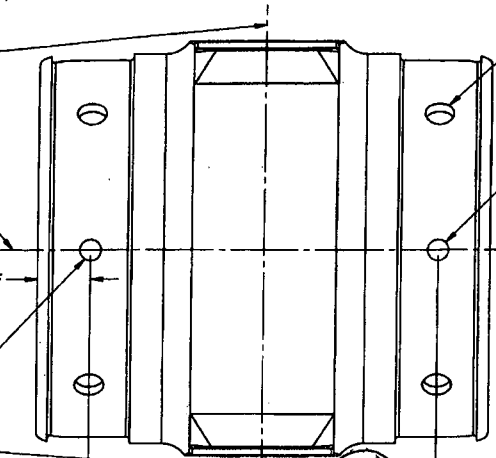
D5122-1 CENTER SUPPORT

HOLES PERPENDICULAR
WITHIN 0.005 OVER
ENTIRE LENGTH

R0.063
AROUND INSIDE EDGE

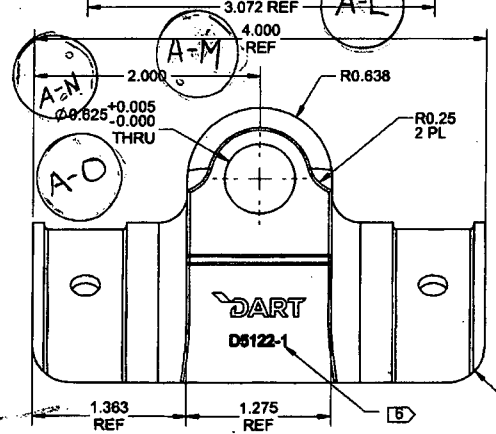
HOLES PERPENDICULAR
WITHIN 0.005 OVER
ENTIRE LENGTH

0.18 X 58° CMF
ALONG TOP EDGE
OF R0.638 (REF) EDGE



OPTIONAL Ø0.261 REF
TOOLING HOLE,
LOCATED AT 45° TO VERTICAL
4 PL

OPTIONAL Ø0.189 REF
TOOLING HOLE,
2 PL



RELEASED
2014-08-25

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	DRAWN	AP		
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	APPROVED	MP	TITLE	SCALE
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